

# Work Order ID 81486

March-14-12 4:21:25 PM

ASAP

\*81486\*

Page 1

Item ID: D2438

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Clamp

Start Date: 14/03/2012 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/14

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2438

Rev C

100

0.00

\*100\*

PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D2438

prog rev: E

dwg rev: E

12 03 18 (100)

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Ensure Material Release Note is attached

12 03 19 (100)

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

(6.786" center to center)

12/3/20 99/100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81486

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**\*81486\***

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Item ID: D2438 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Clamp  
 Start Date: 14/03/2012 Start Qty: 100.00 **\*100\*** Cust Item ID:  
 Required Date: 23/03/2012 Req'd Qty: 100.00 **\*100\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab	Small Fab	0.00				(100)			
Small Fab	Memo 1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709	0.00		SB 12/02/21					
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00				(400)			
Quality Control	Memo	0.00		8/26/22		cuts aspas			
150 <b>*150*</b> Packaging	Identify as per dwg & Stock Location: 456	0.00							
Packaging	Memo	0.00							12/3/22 1000

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*81486\***

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Item ID: D2438      Accept      **\*N900040100\***      Setup      Start      **\*NS1\***  
 Revision ID:      Stop      **\*NS2\***  
 Item Name: Clamp  
 Start Date: 14/03/2012      Start Qty: 100.00      **\*100\***      Cust Item ID:  
 Required Date: 23/03/2012      Req'd Qty: 100.00      **\*100\***      Customer:  
 Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/3/2012

MF  
12-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 81486

\*81486\*

Parent Item: D2438

\*D2438\*

Parent Item Name: Clamp

Start Date: 14/03/2012

Required Date: 23/03/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	254.4860	0.04	4.210526			

\*M304S16GA\*

304/316 Sheet .063

\*\*

W 12 03 18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	254.486	
119653	17.35	
120866	78	
120877	159.136	

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

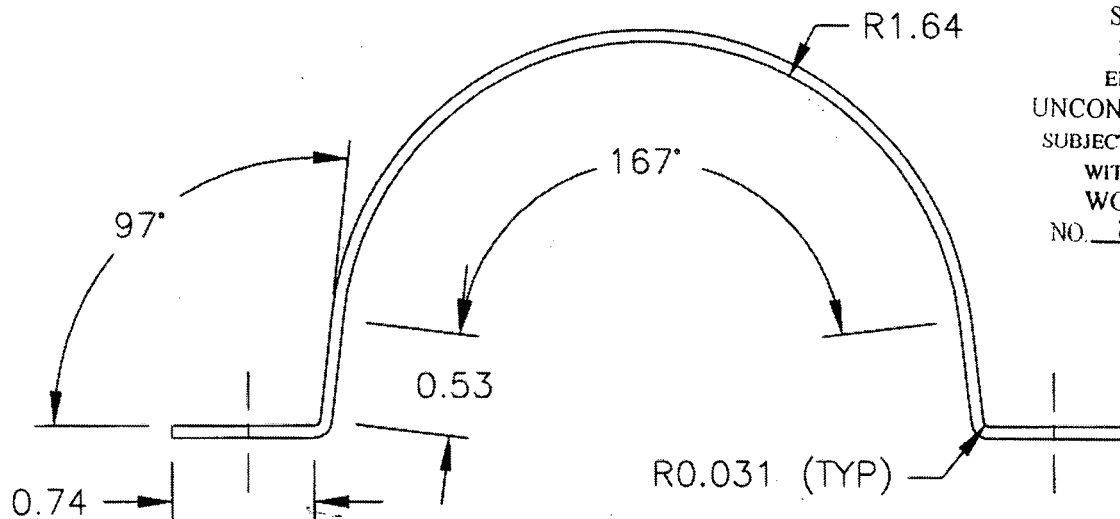
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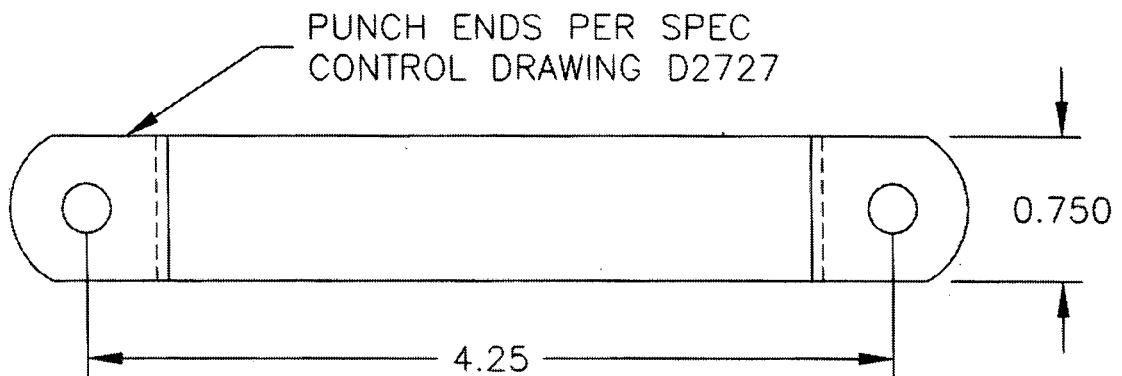
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>CS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED  
98.06.17 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81486 MLU

12/03/14



FLAT LENGTH: 7.586 END-END  
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK  
MINIMUM REQUIREMENT IS ANNEALED CONDITION

# 00.06.06  
CP 00.06.07

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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